



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2580-1

Job Sheet 176983



Part No: D2580-1

Job Qty: 4 ea *3 unit*

Part Name: 205 Bent Tube



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/3/18

Job Tracking No:

Due Date: 5/13/18

Created By: Jason Leroux

Type: Stock

Description:

Note: DWG D2580 REV h SHEETS 1,2,3,8 IPP B 01.11.08 Revised Step 9, 10, 12, and 13 SM IPP Rev:C 10.12.01 as per DEO D1 DD ver:ec

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		5/13/18	0.00	0.00	Start Up Skid tubes		<i>J.Y.</i>
100	Skid tubes	4 pcs		5/13/18	0.00	3.70	Skid tubes		<i>DD</i>
101	QC	4 pcs		5/13/18	0.00	0.00	QC5		<i>BE</i>
110	HandFinish	4 pcs		5/13/18	0.00	1.67	HandFinish1		<i>SA 18-05-10</i>
120	QC	4 pcs		5/13/18	0.00	0.00	QC7		<i>BE</i>
125	Skid tubes	4 pcs		5/13/18	0.00	3.70	Skid tubes		<i>J.Y.</i>
130	QC	4 pcs		5/13/18	0.00	0.00	QC5		<i>BE</i>
140	Packaging	4 pcs		5/13/18	0.00	0.00	Packaging3		
150	QC21-SA	4 Ea		5/13/18	0.00	0.00	QC21		<i>May 16 2018</i>

Part Op 100 - 1- Inspect mat'l D2500-1-190 for damage. 2-Drill pilot holes using drill jig DT 8149 A-BC-D 3-Open holes to 0.508"
Descriptions: as per Dwg D2580 4-Debur holes per QSI002 section 4.2.3 and blow out all chips from inside of tube 5- Test fit inspection saddles on FWD & AFT saddle holes using DT9916.

125 - 1- Bond web in place per QSI 015. A/R Sikaflex-291 batch: *M138 787* Sikaflex expire date: *Dec 2018* Start time and date: _____ bond for 12hrs

140 - LOCATION : LG002

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2500-1-190	Ext'n -I' Beam Tube 4"	4 Ea (1 ea)	90-Start up Operation	<i>5027162</i>
D2596	Web, 205 Skid tube	4 Ea (1 ea)	125-Skid tubes	<i>3068566</i>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2500-1-190	4	58	0
125-Skid tubes	D2596	4	2	0

Part Specifications

Specifications could not be found.



Container No: S070110



Part: D2580 - 1

Job No: 176983

Serial No/Batch: S070110

Revision: H

Inspector:

Dart Aerospace Ltd.
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www.dartaerospace.com

Date: 05/10/18

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE
 QA Closed: **DAS 53** Date: **MAY 2 2 2018**
Work Order update only ☐

Work Order: <u>176983</u> Part No. <u>D2580-1</u> NCR No. <u>18-6867</u>	DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS							
		Skid-tube ☒ Machining ☐ Thermoforming ☐ Large Fab ☐	Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐	Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐	Engineering ☐ Quality ☐ Other ☐				
Date: <u>18-05-15</u>	Step #: <u>125</u>	QTY Effective: <u>①</u>		MRB (QSI042) Approval DAS 9 9-89 <u>18-05-15</u>					
Description Work Order Deviation		Disposition							
<u>web was install backward</u> <u>P.C. procedure not followed</u>		<u>Scrap tube and web</u>		Completed By <u>[Signature]</u> <u>18-05-22</u> Lead hand / Supervisor Approval Verification DAS 9 9-89 <u>18-05-22</u> QC / QA Coordinator Approval DAS 9 9-89 <u>18-05-15</u>					
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☒ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	<table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:33%; vertical-align: top;"> Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ </td> <td style="width:33%; vertical-align: top;"> Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ </td> <td style="width:33%; vertical-align: top;"> Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ ☒ Fit/Function Misaligned/off center ☐ </td> <td style="width:33%; vertical-align: top;"> Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐ </td> </tr> </table>				Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ ☒ Fit/Function Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
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		OTHER: _____							